

# Work Order ID 86940

**\*86940\***

Page 1

July-09-12 2:53:31 PM

Item ID: D3172-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Basket Base Assembly  
 Start Date: 7/09/12 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 8/24/12 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 12/07/10 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3172	Rev C								

100 0.00

**\*100\***

Large Fab

Large Fab

Large Fab

Memo

0.00

- 1-Cut Qty 4 D3166-1 as per Dwg D3172
- 2-Cut 3/4" x 3/4" square tubing as per Dwg D3172
- 3-Drill holes in D3172-3 as per Dwg D3172
- 4-Debur & Remove all markings from material
- 5-Weld as per Dwg D3172 using Welding Table and corner Jig & D3172T1
- 6- Use DT 8996 jig to locate D3174-1 as per dwg
- 7- Debur

*PC 12.11.30*

110 QC9- Inspect visual per QS1004- Fusion Welds 0.00

**\*110\***

QC

Quality Control

Memo

0.00

*12.12.3*



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC6- Inspect dimensions to drawing  Memo	0.00 0.00		DAS 16 9-8 12/12/13			12-12-3		DAS 09 8-89
125 *125* HandFinish Hand Finishing	Pressure Wash per QSI005 4.3  Memo	0.00 0.00				1	16	12-12-4	

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum  Memo 1ST COAT: 10-00 START TIME: 400 0F OVEN TEMPERATURE: 400 FINISH TIME: 10-30 ***** 2nd coat if necessary***** 2ND COAT: 10-50 START TIME: 400 0F OVEN TEMPERATURE: 400 FINISH TIME: 11-20	0.00  0.00				1X			MT 12/12/04
140 <b>*140*</b> QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00				1			BR-DH.

W23383

W/O:		WORK ORDER CHANGES					
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Page 4

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 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location	0.00	87491			1	0	12/12-4	
*150*									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
*160*									
QC	Memo	0.00							
Quality Control									

12/12/7 JG  
 MF  
 12-12-06

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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# Picklist Print

July-09-12 2:53:29 PM

Page 1

Work Order ID: 86940

Parent Item: D3172-041

Parent Item Name: Basket Base Assembly

Start Date: 7/09/12

Required Date: 8/24/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:B04.01.05 Added Step 5 inspection KJ/RF  
IPP Rev:C 08-08-29 revC as per dwg DD verified by:EC  
pressure wash DD VERF:EC  
IPP Rev:D 11.04.04 added

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2012-117 Clevis		Manufactured	No			100	Each	33.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		33							
				55729		2							
				69890		31							
D2232-3 Basket Hinge		Manufactured	No			100	Each	27.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		25							
				82304		3							
				85698		10							
				86362		12							
				WA005		2							
				75581		2							
D2327-3 Spacer Bushing		Manufactured	No			100	Each	26.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		22							
				82325		22							
				WA005		4							
				75564		1							
				77229		1							
				81144		2							

B69890 → 2x SJ 12.11.27

B86914 → 1x SJ 12.11.27  
B86362 → 1x

B88561 → 2x SJ 12.11.27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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July-09-12 2:53:30 PM

Page 2

Work Order ID: 86940

Parent Item: D3172-041

Parent Item Name: Basket Base Assembly

Start Date: 7/09/12

Required Date: 8/24/12

Start Qty: 1.00

Required Qty: 1.00

D2581 Manufactured No 100 Each 59.0000  
Mounting Bracket

<sup>2</sup> ~~B88574~~ → 2x *SY 12.11.27*

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	37	
82506	2	
83230	3	
85436	8	
85452	24	
WA005	22	
70766	2	
81253	1	
82897	19	

D3166-1 Manufactured No 100 Each 10.0000  
Basket Hoop

<sup>4</sup> ~~B86807~~ → 4x *SY 12.11.27*

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	10	
84712	10	

D3174-1 Manufactured No 100 Each 18.0000  
Mounting Lug

<sup>8</sup> ~~B86122~~ → 8x *SY 12.11.27*

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	12	
86122	12	
WA005	6	
71272	6	

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 3

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Parent Item: D3172-041

Parent Item Name: Basket Base Assembly

Start Date: 7/09/12

Required Date: 8/24/12

Start Qty: 1.00

Required Qty: 1.00

M304EX0.75-16F  
Expanded Metal Flat SS

Purchased No

100 sf 986.7385 48

48  
12.12.07  
M123200 → 48

Location	Loc Qty	Loc Code
WA	4.9094	
121738	4.9094	
WA035	981.8290637	
117197	102.9036	
120917	82.62533	
121521	0.00013372	
122080	208.3	
122138	268	
122315	320	

M304TS0.750W.065  
304 SQ Tube .75x.75x.065W

Purchased No

100 f 1,293.1169 51 53.684211

Location	Loc Qty	Loc Code
MAT	1000	
112398	0	
122051	1000	
MAT017	252.1169370	
120267	26.9468670	
120633	225.17007	
MAT018	41	
7636	41	

4122051 → 53.68 + 3'  
JUD MAT  
12.12.07 Scrap

W/O:		WORK ORDER CHANGES					
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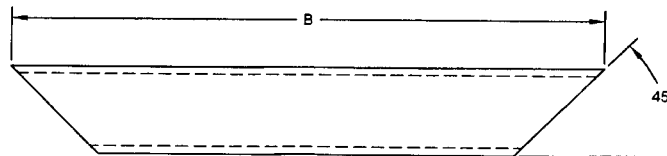
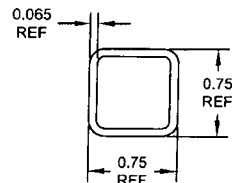
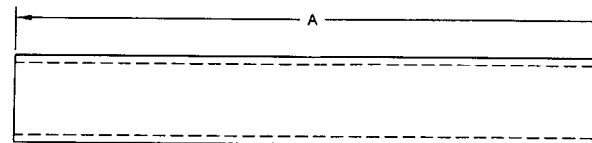
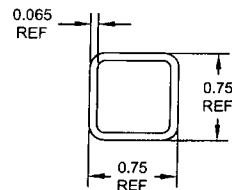
**NOTE:** Date & initial all entries

# PARTS LIST FOR D3172-041 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D3172-1	2	—	96.00	RIB
D3172-3	2	—	25.50	RIB
D3172-5	6	33.09	—	RIB
D3172-7	3	26.81	—	RIB
D3172-9	1	94.50	N/A	RIB
D2012-117	4	N/A	N/A	CLEVIS
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MOUNTING BRACKET
D2232-3	2	N/A	N/A	HINGE PLATE
D3166-1	4	N/A	N/A	RIB
D3174-1	8	N/A	N/A	MOUNTING LUG

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO 80940 MJS  
12/07/10



RELEASED  
08-08-21/10

C	FRAME MATERIAL WAS 0.060 WALL. MESH MATERIAL UPDATED. DRAWING MOVED TO "B" FORMAT AND UPDATED TO CURRENT STANDARDS.	AJS	08.07.03
B	ADD D3172-9 & D2012-117	CP	03.01.07
A	NEW ISSUE	DS	02.12.02
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3172	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (EC130)	NTS
DATE	08.07.03	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

**NOTES:**  
1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING  
REF. DART SPEC M304TS0.75W.065

2) MESH MATERIAL: 3/4-16F EXPANDED SS  
REF DART SPEC M304EX0.75-16F

3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3

4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

7) IDENTIFICATION: NONE

8) WEIGHT: N/A

9) WELD PER DART QSI 004

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

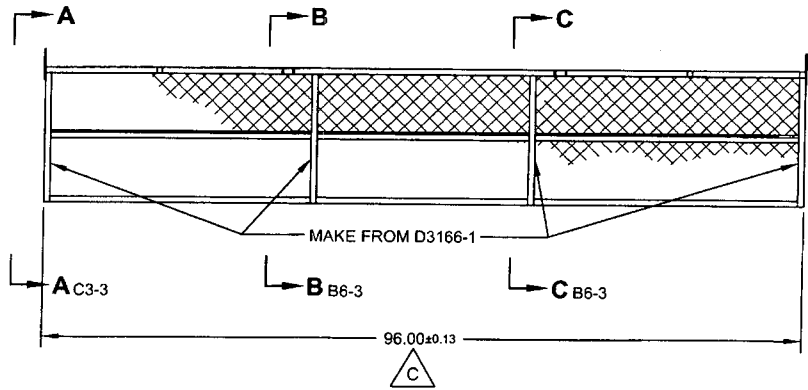
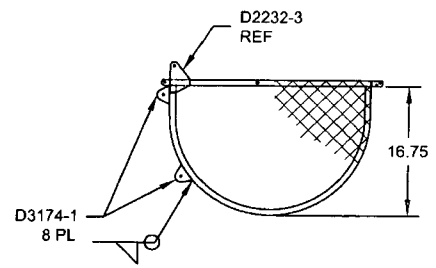
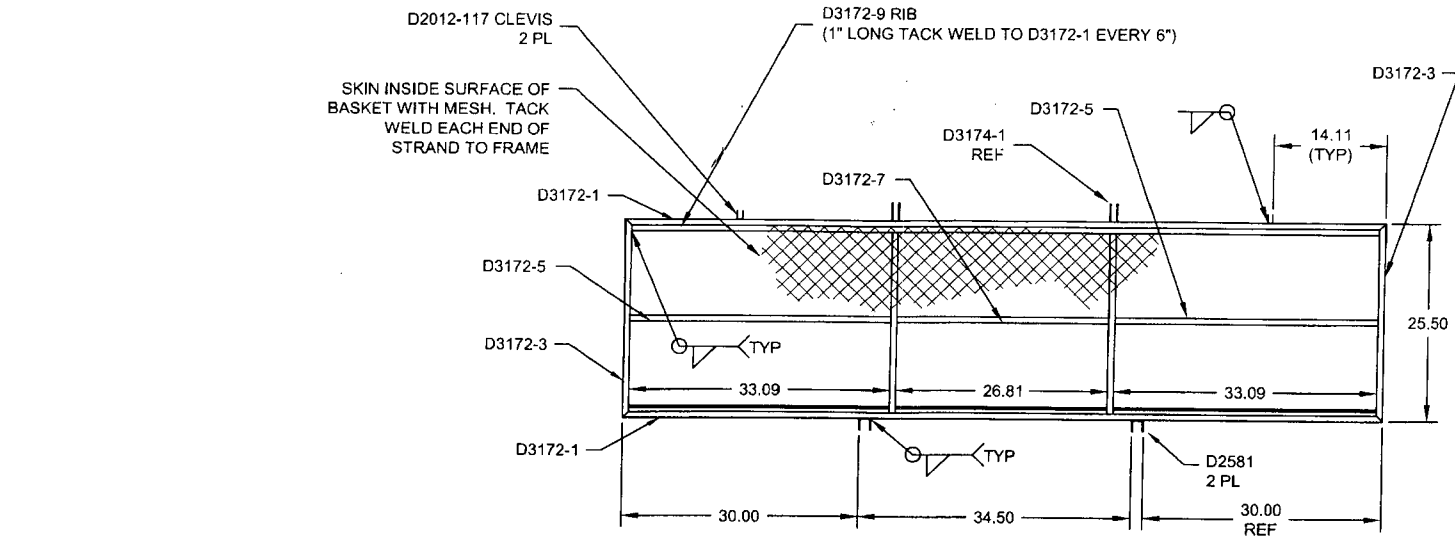
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**NOTE:** Date & initial all entries







86940



**D3172-041 BASKET BASE ASSEMBLY**

**RELEASED**

DESIGN	CP	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3172	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (EC130)	NTS
DATE	08.07.03	COPYRIGHT © 2002 BY DART AEROSPACE LTD	
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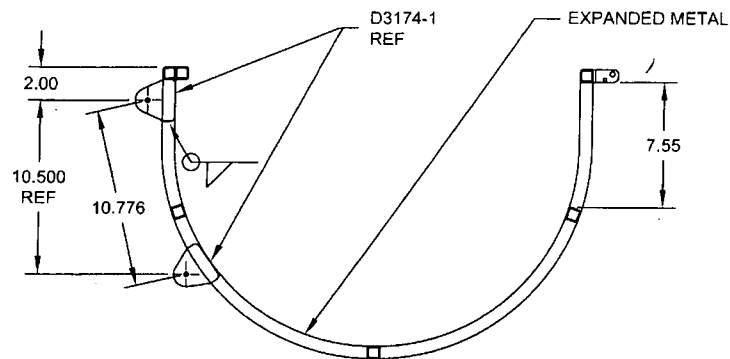
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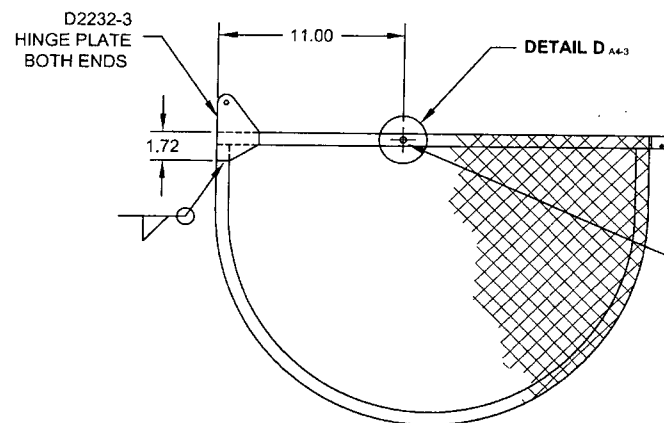
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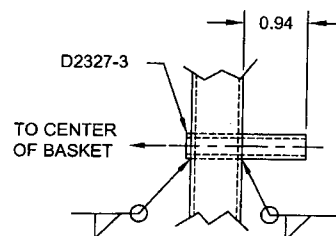
**NOTE:** Date & initial all entries



**SECTION B-B<sup>B5-2</sup>  
AND SECTION C-C<sup>B3-2</sup>**  
RIB DETAIL  
SCALE 2X






**SECTION A-A<sup>B5-2</sup>**  
SPACER DETAIL  
SCALE 2X



**DETAIL D<sup>D3-3</sup>**  
SCALE 4X

RELEASED  
08-08-11/14

DESIGN	CP	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3172	SHEET 3 OF 3
APPROVED		TITLE	SCALE
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